



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200  
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**4.5NR-52**  
**Job Sheet 192524**



**Part No:** 4.5NR-52

**Job Qty:** 12 pcs

DAG  
21  
9-28

**Part Name:** Keeper Bushing



**Part Weight:** 0 lbs

**Status:** New

**Priority:** Medium

**Job Created:** 3/27/19

**Job Tracking No:**

**Due Date:** 3/29/19

**Created By:** Marie Lajeunesse

**Type:** SOLD

**Description:**

**Note:** DWG 4.5NR-52 REV 3 IPP Rev. A 19.03.27 New issue DP Verify DD

**Ship Via:**

### Bill of Materials

### Job Routing

| Op<br>No | Operation  | Qty    | Start Date | Due<br>Date | Standard     |            | Workcenter/Supplier   |           | Sign-off |
|----------|------------|--------|------------|-------------|--------------|------------|-----------------------|-----------|----------|
|          |            |        |            |             | Setup<br>Hrs | Run<br>Hrs | Workcenter / Supplier | Lead Time |          |
| 120      | SL-154 - 1 | 12 pcs | 3/29/19    | 3/29/19     | 0.50         | 2.00       | SL-154 - 1            |           | 19/03/28 |
| 130      | QC 2       | 12 pcs | 3/29/19    | 3/29/19     | 0.00         | 0.00       | QC 2 - 1              |           |          |
|          |            |        |            |             |              |            | QC 2 - 12             |           |          |
|          |            |        |            |             |              |            | QC 2 - 14             |           |          |
|          |            |        |            |             |              |            | QC 2 - 17             |           |          |
|          |            |        |            |             |              |            | QC 2 - 19             |           |          |
|          |            |        |            |             |              |            | QC 2 - 2              |           |          |
|          |            |        |            |             |              |            | QC 2 - 20             |           |          |
|          |            |        |            |             |              |            | QC 2 - 22             |           |          |
|          |            |        |            |             |              |            | QC 2 - 23             |           |          |
|          |            |        |            |             |              |            | QC 2 - 25             |           |          |
|          |            |        |            |             |              |            | QC 2 - 32             |           |          |
|          |            |        |            |             |              |            | QC 2 - 33             |           | 19/03/28 |
|          |            |        |            |             |              |            | QC 2 - 35             |           |          |
|          |            |        |            |             |              |            | QC 2 - 39             |           |          |
|          |            |        |            |             |              |            | QC 2 - 4              |           |          |
|          |            |        |            |             |              |            | QC 2 - 40             |           |          |
|          |            |        |            |             |              |            | QC 2 - 44             |           |          |
|          |            |        |            |             |              |            | QC 2 - 45             |           |          |
|          |            |        |            |             |              |            | QC 2 - 48             |           |          |
|          |            |        |            |             |              |            | QC 2 - 49             |           |          |
|          |            |        |            |             |              |            | QC 2 - 50             |           |          |
|          |            |        |            |             |              |            | QC 2 - 51             |           |          |
|          |            |        |            |             |              |            | QC 2 - 52             |           |          |
|          |            |        |            |             |              |            | QC 2 - 56             |           |          |
|          |            |        |            |             |              |            | QC 2 - 57             |           |          |
|          |            |        |            |             |              |            | QC 2 - 62             |           |          |
|          |            |        |            |             |              |            | QC 2 - 63             |           |          |
|          |            |        |            |             |              |            | QC 2 - 8              |           |          |
|          |            |        |            |             |              |            | QC 2 - 66             |           |          |
|          |            |        |            |             |              |            | QC 2 - 64             |           |          |



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**Container No:** S167258



**Part:** 4.5NR-52

**Job No:** 192524

**Serial No/Batch:** S167258

**Revision:** 3

**Inspector:**

**Exp Date:**

**Instructions:**

**Date:** 03/28/19

|                                 |        |         |           |                        |              |
|---------------------------------|--------|---------|-----------|------------------------|--------------|
| 140 QC 8                        | 12 pcs | 3/29/19 | 0.00 0.00 | QC 2 - 65              |              |
|                                 |        |         |           | QC 2 - 5               |              |
|                                 |        |         |           | QC 8 - 12              |              |
|                                 |        |         |           | QC 8 - 14              |              |
|                                 |        |         |           | QC 8 - 17              |              |
|                                 |        |         |           | QC 8 - 20              |              |
|                                 |        |         |           | QC 8 - 25              |              |
|                                 |        |         |           | QC 8 - 3               |              |
|                                 |        |         |           | QC 8 - 32              |              |
|                                 |        |         |           | QC 8 - 33              |              |
|                                 |        |         |           | QC 8 - 35              |              |
|                                 |        |         |           | QC 8 - 39              |              |
|                                 |        |         |           | QC 8 - 4               |              |
|                                 |        |         |           | QC 8 - 44              |              |
|                                 |        |         |           | QC 8 - 45              |              |
|                                 |        |         |           | QC 8 - 49              |              |
|                                 |        |         |           | QC 8 - 58              |              |
|                                 |        |         |           | QC 8 - 8               | B.E 19-05-29 |
|                                 |        |         |           | QC 8 - 9               |              |
|                                 |        |         |           | QC 8 - 68              |              |
|                                 |        |         |           | QC 8 - 67              |              |
|                                 |        |         |           | QC 8 - 1 (A)           |              |
|                                 |        |         |           | QC 8 - 47              |              |
|                                 |        |         |           | QC 8 - 40              |              |
|                                 |        |         |           | QC 8 - 52              |              |
|                                 |        |         |           | QC 8 - 23              |              |
| 150 Packaging 3-1 - Stock - B4B | 12 pcs | 3/29/19 | 0.00 0.00 | Packaging 3 - 1 - B4B  |              |
|                                 |        |         |           | Packaging 3 - 2 - B4B  |              |
|                                 |        |         |           | Packaging 3 - 3 - B4B  |              |
|                                 |        |         |           | Packaging 3 - 4 - B4B  |              |
|                                 |        |         |           | Packaging 3 - 5 - B4B  | DAS          |
|                                 |        |         |           | Packaging 3 - 6 - B4B  | 28           |
|                                 |        |         |           | Packaging 3 - 7 - B4B  | 9-89         |
|                                 |        |         |           | Packaging 3 - 8 - B4B  |              |
|                                 |        |         |           | Packaging 3 - 9 - B4B  |              |
|                                 |        |         |           | Packaging 3 - 10 - B4B |              |
|                                 |        |         |           | Packaging 3 - 11 - B4B |              |
|                                 |        |         |           | Packaging 3 - 12 - B4B |              |
|                                 |        |         |           | Packaging 3 - 13 - B4B |              |
|                                 |        |         |           | Packaging 3 - 14 - B4B |              |
|                                 |        |         |           | Packaging 3 - 15 - B4B |              |
|                                 |        |         |           | Packaging 3 - 16 - B4B |              |
|                                 |        |         |           | Packaging 3 - 17 - B4B |              |
|                                 |        |         |           | Packaging 3 - 18 - B4B |              |
|                                 |        |         |           | Packaging 3 - 19 - B4B |              |
|                                 |        |         |           | Packaging 3 - 20 - B4B |              |
|                                 |        |         |           | Packaging 3 - 21 - B4B |              |
|                                 |        |         |           | Packaging 3 - 22 - B4B |              |
|                                 |        |         |           | Packaging 3 - 23 - B4B |              |
|                                 |        |         |           | Packaging 3 - 24 - B4B |              |
|                                 |        |         |           | Packaging 3 - 25 - B4B |              |
|                                 |        |         |           | Packaging 3 - 26 - B4B |              |
|                                 |        |         |           | Packaging 3 - 27 - B4B |              |
|                                 |        |         |           | Packaging 3 - 28 - B4B |              |
|                                 |        |         |           | Packaging 3 - 29 - B4B |              |
|                                 |        |         |           | Packaging 3 - 30 - B4B |              |
|                                 |        |         |           | Packaging 3 - 31 - B4B |              |
|                                 |        |         |           | Packaging 3 - 32 - B4B |              |
|                                 |        |         |           | Packaging 3 - 33 - B4B |              |

|                                                                                                                                                                                                                                                                                                                                        |                                |                    |                  |                        |                |
|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------------------|--------------------|------------------|------------------------|----------------|
|                                                                                                                                                                                                                                                                                                                                        |                                |                    |                  | Packaging 3 - 34 - B4B |                |
|                                                                                                                                                                                                                                                                                                                                        |                                |                    |                  | Packaging 3 - 35 - B4B |                |
|                                                                                                                                                                                                                                                                                                                                        |                                |                    |                  | Packaging 3 - 36 - B4B | DAG            |
| 160 QC 21 - SA                                                                                                                                                                                                                                                                                                                         | 12 pcs                         | 3/29/19            | 0.00 0.00        |                        | 21 APR 01 2019 |
| Part Op 120 - 1-Machine as per folio FC719 FOLIO REV: _____ DWG REV: _____ 2-Debur<br>Descriptions: 130 - QC2- Inspect parts off machine FAI/FAIB<br>140 - QC8- Inspect parts - second check<br>150 - Identify as per dwg & Stock Location: _____ BAG & LABEL WITH BATCH NUMBER.<br>160 - QC21- Final Inspection - Work Order Release) |                                |                    |                  |                        |                |
| <b>Job BOM</b>                                                                                                                                                                                                                                                                                                                         |                                |                    |                  |                        |                |
| <b>Part / Item</b>                                                                                                                                                                                                                                                                                                                     | <b>Component Name</b>          | <b>Quantity</b>    | <b>Operation</b> | <b>Container</b>       |                |
| MT-BRONZE-C63000-R0.500                                                                                                                                                                                                                                                                                                                | Bronze C63000 Round Bar 0.500" | 1.3200 ft (.11 ea) | 120-SL-154 - 1   | 5038030                |                |
| <b>Job Allocations</b>                                                                                                                                                                                                                                                                                                                 |                                |                    |                  |                        |                |
| <b>Operation</b>                                                                                                                                                                                                                                                                                                                       | <b>Component Part</b>          | <b>Required</b>    | <b>Inventory</b> | <b>Allocated</b>       |                |
| 120-SL-154 - 1                                                                                                                                                                                                                                                                                                                         | MT-BRONZE-C63000-R0.500        | 1                  | 2                | 0                      |                |
| <b>Part Specifications</b>                                                                                                                                                                                                                                                                                                             |                                |                    |                  |                        |                |
| Specifications could not be found.                                                                                                                                                                                                                                                                                                     |                                |                    |                  |                        |                |

Plex 3/27/19 9:12 AM Dart.lajeunesse.marie

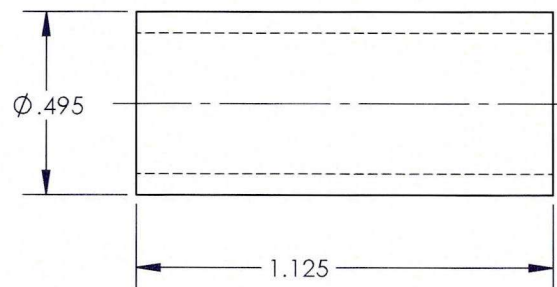
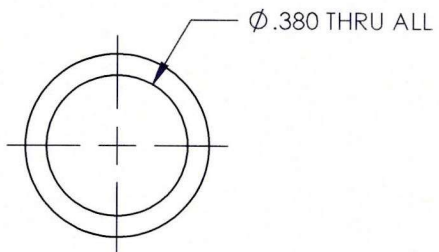
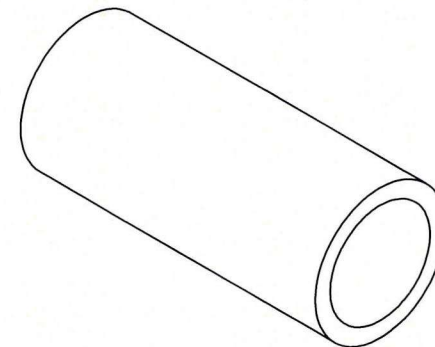




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| REVISIONS |         |                                                                     |           |         |          |
|-----------|---------|---------------------------------------------------------------------|-----------|---------|----------|
| REV       | ECR     | DESCRIPTION                                                         | DATE      | INITIAL | APPROVED |
| 2         |         | AS DRAWN BY APICAL.                                                 | 7/16/2013 | JAG     |          |
| 2A        | 14-0095 | CH'D TITLE BLOCK WAS RED BARN IS DART. ADDED BAG & LABEL NOTE.      | 7/28/2014 | DPD     | RW       |
| 3         | 16-0094 | UPDATED TO NEW STANDARD. CH'D MAT'L WAS AL-BRONZE IS 630-AL-BRONZE. | 8/4/2016  | DEW     | SM       |

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WITHOUT NOTICE  
WORK ORDER  
NO. 192524 M15  
1903-27



Ø.500

NOTE:  
BAG & LABEL WITH BATCH NUMBER.

|                                                                                                                                                                                                                                                                                                    |                    |
|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------|
| <b>DART<br/>AEROSPACE</b>                                                                                                                                                                                                                                                                          |                    |
| TITLE<br><b>KEEPER BUSHING</b>                                                                                                                                                                                                                                                                     |                    |
| DWG NO.<br><b>4.5NR-52</b>                                                                                                                                                                                                                                                                         | REV<br><b>3</b>    |
| MAT'L 630-AL-BRONZE<br>HEAT TREAT<br>FINISH<br>SPEC<br>DRAWN BY: APICAL<br>CHECKED: DUERFELDT<br>OPPTS APPR: ANDERSON<br>QA APPR: LINDSAY<br>APPROVED: MACKOVJAK                                                                                                                                   |                    |
| UNLESS OTHERWISE SPECIFIED<br>DIMENSIONS ARE IN INCHES<br>.XXX ± .005 FRACTIONS ± 1/8<br>.XX ± .01 ANGLES ± 5°<br>.X ± .1 SURFACES = 125° ✓<br>1. BREAK ALL SHARP EDGES<br>.015 x 45° OR .015R<br>2. DIMENSIONAL LIMITS APPLY<br>AFTER PLATING<br>3. INTERPRET DIM AND TOL PER<br>ASME Y14.5M-2009 |                    |
| USED ON MODEL                                                                                                                                                                                                                                                                                      |                    |
| SCALE<br>2:1                                                                                                                                                                                                                                                                                       | DATE<br>12/23/1997 |
| SHEET 1 OF 1                                                                                                                                                                                                                                                                                       |                    |

| ASSY QTY | ASSY QTY | B/O | Part #   | UNIT QTY | Description    | Material      | B/O INFORMATION OR SPECIFICATIONS |
|----------|----------|-----|----------|----------|----------------|---------------|-----------------------------------|
|          |          |     | 4.5NR-52 | 1        | KEEPER BUSHING | 630-AL-BRONZE |                                   |